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RBEB290-P0001-101
Job Sheet 195663



Part No: RBEB290-P0001-101

Job Qty: 1 pcs

Part Name: Alignment Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/29/19

Job Tracking No:

Due Date: 6/10/19

Created By: Marie Lajeunesse

Type: SOLD

Description: *order 14962*

Note: DWG RBEB290-P0001-101 Rev A IPP Rev. A 19.05.28 New issue DP Verify DD

Ship Via:



Dart Aerospace Ltd.
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Hawkesbury, ON K6A 1K7
CANADA
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Container No: S193571



Part: RBEB290-P0001-101

Job No: 195663

Serial No/Batch: S193571

Revision: A

Inspector:

Exp Date:

Instructions:

Date: 06/25/19

Job Routing								
Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup Hrs	Run Hrs	Workcenter / Supplier Lead Time	Sign-off
100	Small Fab - 1	1 pcs	6/10/19		0.00	0.33	Small Fab - 1	MLL
							Small Fab - 2	
							Small Fab - 3	
							Small Fab - 4	
							Small Fab - 5	
							Small Fab - 6	
							Small Fab - 7	
110	QC 5	1 pcs	6/10/19		0.00	0.00	QC 5 - 10	DAS 40 9-89
							QC 5 - 12	
							QC 5 - 17	
							QC 5 - 18	
							QC 5 - 19	
							QC 5 - 22	
							QC 5 - 24	
							QC 5 - 3	
							QC 5 - 43	
							QC 5 - 49	
							QC 5 - 51	
							QC 5 - 58	
							QC 5 - 68	
							QC 5 - 9	
							QC 5 - 50	
							QC 5 - 30	
							QC 5 - 40	
120	Packaging 3-1 - Stock - B4B	1 pcs	6/10/19		0.00	0.00	Packaging 3 - 1 - B4B	JUN 2 5 2019 DAS 40 9-89
							Packaging 3 - 2 - B4B	
							Packaging 3 - 3 - B4B	
							Packaging 3 - 4 - B4B	
							Packaging 3 - 5 - B4B	
							Packaging 3 - 6 - B4B	
							Packaging 3 - 7 - B4B	
							Packaging 3 - 8 - B4B	
							Packaging 3 - 9 - B4B	
							Packaging 3 - 10 - B4B	
130	QC 21 - FG	1 pcs	6/10/19		0.00	0.00	QC 21 - FG - 21	JUN 2 5 2019 DAS 70 9-89
							QC 21 - FG - 70	
							QC 21 - SA - 53	

Part Op 100 - 1-ASSEMBLE AS SHOWN. Sheet 1 and 2. See notes 7 through 13. 2-CUT TO 1.75" LENGTH THEN ASSEMBLE
 Descriptions: WITH ITEM -1 AS SHOWN 3-CUT TO 2.50" LENGTH THEN ASSEMBLE WITH ITEM -1 AS SHOWN 4-CUT TO 6.38" LENGTH THEN ASSEMBLE WITH ITEM -1 AS SHOWN 5-CUT TO 7.00" LENGTH THEN ASSEMBLE WITH ITEM -1 AS SHOWN 6-ASSEMBLE ITEMS -7, -9, AND -11 ADHESIVE SIDE ON ITEM -1 AS SHOWN, AND CUT EXCESS IF NECESSARY 7-APPLY INSTANT ADHESIVE LOCTITE 495 BETWEEN THE SURFACES OF ITEMS -7, -9, AND-11, AND ITEM -1 IF NECESSARY, AND REMOVE EXCESS

120 - The tool must be packaged with a desiccant bag into a tight fitting sealed plastic bag as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
70 24175K46	Rubber U-Channel Push-On Trim 31/64" Inside Ht. X 1/8" Inside Width	2.9500 ft (2.95 ea)	100-Small Fab - 1	5185543
56 93635A208	316 SS Hex Head Screw M6 X 1 mm X 12 mm Long	2 Ea (2 ea)	100-Small Fab - 1	5185549
58 95211A160	316 SS Washer 6.4 mm ID. X 18.0 mm OD. X 1.4-1.8 mm Thick	2 Ea (2 ea)	100-Small Fab - 1	5185558
51309 MS20470AD5-6	Rivet	4 Ea (4 ea)	100-Small Fab - 1	5048897
RBEB290-P0001-101-1	Saddle	1 pcs (1 ea)	100-Small Fab - 1	5187898
24 RBEB290-P0001-101-11	Pad w/Adhesive Backing	1 pcs (1 ea)	100-Small Fab - 1	5189470
140B RBEB290-P0001-101-12	Adapter Assembly	1 pcs (1 ea)	100-Small Fab - 1	5192514
RBEB290-P0001-101-3	Vertical Plate	1 pcs (1 ea)	100-Small Fab - 1	5188192
24 RBEB290-P0001-101-7	Center Pad	1 pcs (1 ea)	100-Small Fab - 1	5189545
140B RBEB290-P0001-101-9	Back Pad	1 pcs (1 ea)	100-Small Fab - 1	5189584

Job Allocations

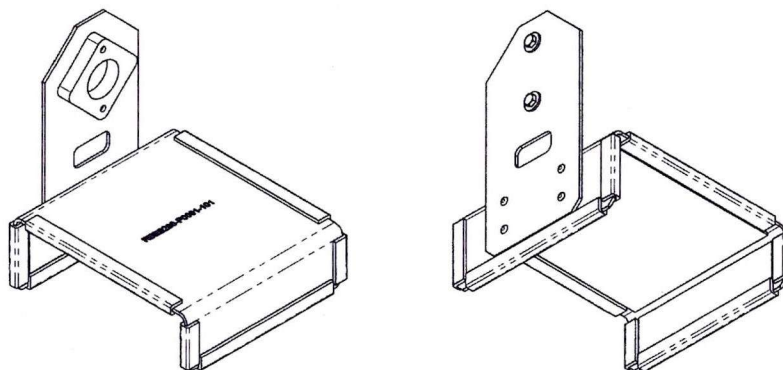
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	24175K46	3	0	0
	93635A208	2	0	0
	95211A160	2	0	0
	MS20470AD5-6	4	741	0
	RBEB290-P0001-101-1	1	0	0
	RBEB290-P0001-101-11	1	0	0
	RBEB290-P0001-101-12	1	0	0
	RBEB290-P0001-101-3	1	0	0
	RBEB290-P0001-101-7	1	0	0
	RBEB290-P0001-101-9	1	0	0

Part Specifications

Specifications could not be found.

Plex 5/29/19 10:54 AM Dart.lajeunesse.marie

ITEM #	QTY	PART #	PART TITLE
-1	1	RBEB290-P0001-101-1	BASE
-3	1	RBEB290-P0001-101-3	PLATE
-7	1	RBEB290-P0001-101-7	CENTER PAD
-9	1	RBEB290-P0001-101-9	BACK PAD
-11	1	RBEB290-P0001-101-11	FRONT PAD
-12	1	RBEB290-P0001-101-12	ADAPTER ASSEMBLY
13	8	McMaster#24175K46 OR EQUIV.	RUBBER U-CHANNEL PUSH-ON TRIM 31/64" INSIDE HT. X 1/8" INSIDE WD.
14	2	McMaster#93635A208 OR EQUIV.	316 SS HEX HEAD SCREW M6 X 1 mm X 12 mm LG.
15	2	McMaster#95211A160 OR EQUIV.	316 SS WASHER 6.4 mm ID. X 18.0 mm OD. X 1.4-1.8 mm THK.
16	4	MS20470AD5-6	RIVET



RBEB290-P0001-101 ALIGNMENT TOOL

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NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) CUT TO 1.75" LENGTH THEN ASSEMBLE WITH ITEM -1 AS SHOWN
- 9) CUT TO 2.50" LENGTH THEN ASSEMBLE WITH ITEM -1 AS SHOWN
- 10) CUT TO 6.38" LENGTH THEN ASSEMBLE WITH ITEM -1 AS SHOWN
- 11) CUT TO 7.00" LENGTH THEN ASSEMBLE WITH ITEM -1 AS SHOWN
- 12) ASSEMBLE ITEMS -7, -9, AND -11 ADHESIVE SIDE ON ITEM -1 AS SHOWN, AND CUT EXCESS IF NECESSARY
- 13) APPLY INSTANT ADHESIVE LOCTITE 495 BETWEEN THE SURFACES OF ITEMS -7, -9, AND -11, AND ITEM -1 IF NECESSARY, AND REMOVE EXCESS
- 14) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 195663 MWS
19-05-29

SEE PREVIOUS REVISION FOR MORE INFORMATION			
UPDATED DRAWING TEMPLATE			
ADDED ITEMS -12 AND 15 ADDED DRAWINGS FOR ITEMS -7, -9, -11, AND -12			
ITEM 13 WAS MCMaster-CARR #8672K41 IS McMaster#24175K46 ITEM 14 WAS MCMaster-CARR #91280A324 IS McMaster#93635A208 ITEM 16 WAS MCMaster-CARR #9748A243 IS MS20470AD5-6			
-1 ADDED FLAT PATTERN. MATERIAL WAS 5052 IS 6061-T6 / 7075-T6. FINISH WAS PAINT TEMPO GREEN IS ANODIZE RED. DIM WAS Ø .188 (x4) IS Ø 0.161 THRU 4 PL. DIM WAS 1.187 (x2) IS 1.175 2 PL. DIM WAS 3.125 IS 3.16. DIM WAS .120 IS 0.13. DIM WAS R.019 (x2) IS R0.25 2 PL. DIM WAS 8.43 IS 8.38. REMOVED 1.375, 3.75, .72 (x2) DIMS		19-725	KPT
-3 MATERIAL WAS 6061 IS 6061-T6 / 7075-T6. FINISH WAS PAINT TEMPO GREEN IS ANODIZE RED. DIM WAS .44x45" (x2) IS 0.40 X 45.0" CMF 2 PL. DIM WAS 1.1875 (x2) IS 1.175 2 PL. DIM WAS 2.870 IS 2.475. DIM WAS 1.63x45" (x2) IS 1.56 X 45.0" 2 PL. DIM WAS .12 IS 0.13. DIM WAS R.187 (x4) IS R0.25 4 PL. DIM WAS Ø .188 (x8) IS Ø 0.161 THRU 4 PL. REMOVED 1.375, 2.477 (x2), .56, .75, 4.50, 2.25 DIMS. ADDED Ø 0.261 THRU 2 PL. 0.998, 3.10, 0.875 2 PL DIMS			
-5 MATERIAL WAS 6061 IS 6061-T6 / 7075-T6. FINISH WAS CLEAR ANODIZE IS ANODIZE RED. DIM WAS 2.50 IS 2.52. DIM WAS M6x1 (x2) IS TAP FOR M6 X 1.0 HELICOIL INSERT THRU 2 PL. DIM WAS 0.547 IS 0.56. REMOVED 2.50, .944 (x2), REF. (x2) B.C. Ø 2.670 @ 45°, .06x45" DIMS. ADDED R0.31 4 PL, 2.475 DIMS			
REV.	DESCRIPTION	ECN #	BY
DESIGN	KPT		
DRAWN	KPT		
CHECKED	KPT		
MFG. APPR.	DP		
APPROVED	V		
DATE 27/05/2019			
TOOL PART # RBEB290-P0001-101		REV. A SHEET 1 OF 9	
TITLE ALIGNMENT TOOL		SCALE NTS	
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DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

TOOL PART #
RBEB290-P0001-101

TITLE
ALIGNMENT TOOL

DATE 27/05/2019

SCALE
NTS

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

